

Work Order ID 130272

130272

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March-02-15 3:11:07 PM

Item ID: D3512-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate
 Start Date: 3/02/15 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 3/06/15 Req'd Qty: 8.00 *8* Customer:

Reference:

Approvals: Process Plan: AW Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3512	D

120

0.00

120

Large Fab

Large Fab

Memo

0.00

Large Fab

1- Weld hard surface using DT8874 as per Dwg D3512 & QSI 004

A/R 2059b Hardcoat Rod M127456

2- Weld D3512-3 spacer to D3512-1 as per dwg

A/R S.S. Rod M123823

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00

130

QC

Memo

0.00

Quality Control

x12 15-03-03 MAL

12 15-3-4 DAS 50 9-89

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Item ID: D3512-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate

Start Date: 3/02/15

Start Qty: 8.00

8

Cust Item ID:

Required Date: 3/06/15

Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

DAS

50

9-89

DAS

38

9-89

142

0.00

142

HandFinish

Memo

0.00

Hand Finishing

Coat wearplate with rockguard as per Dwg and note #9

Batch: 131451

12

CR 15-03-06

144

QC5- Inspect part completeness to step on W/O

0.00

144

QC

Memo

0.00

Quality Control

DAS

38

9-89

(12)

MAR 05 2015

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Item ID: D3512-041 Accept ***N900040100*** Setup Start ***NS1***
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>ST6A</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12 MAR 10 2015

MCS 15-03-11

MUF 15-3-10

Picklist Print

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Work Order ID: 130272

130272

Parent Item: D3512-041

D3512-041

Parent Item Name: Wearplate

Start Date: 3/02/15

Required Date: 3/06/15

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 13.07.19 NEW ISSUE DD VERF:JLM IPP
REV:B 13.12.11 ECN13-619/REV.D DWG DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3512-1		Manufactured	No				Each	25.0000		8			

D3512-1

Wearplate

Location	Loc Qty	Loc Code
FG	2	
89154	2	
ST617	23	
<u>123367</u> x12	12	
124211	11	

x12 15-03-03 MAL

D3512-3

Manufactured No

Each 21.0000

8

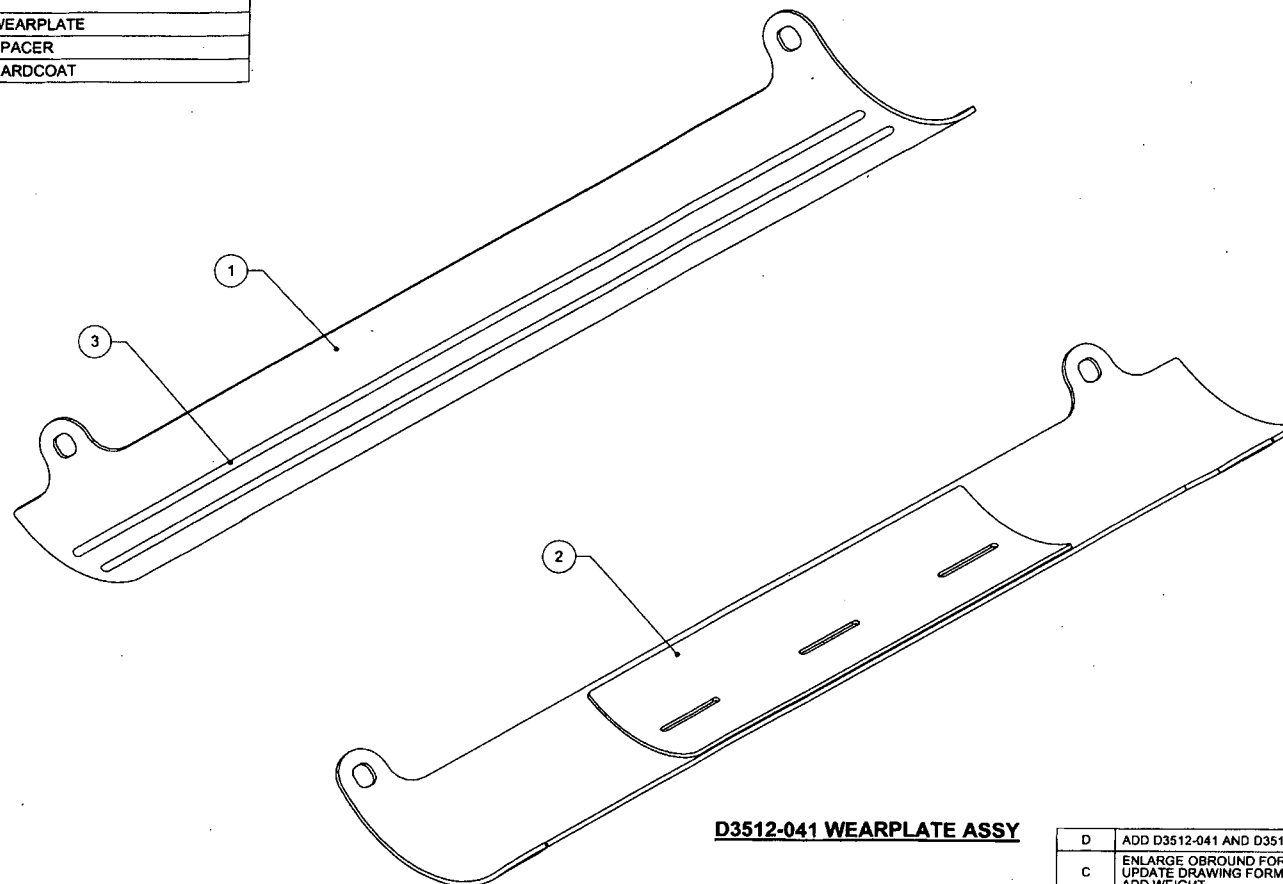
D3512-3

Spacer

Location	Loc Qty	Loc Code
WA001	21	
<u>113589</u> x9	9	
<u>123329</u> x3	12	

x12 15-03-03 MAL

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3512-041	WEARPLATE ASSY
1	1	D3512-1	WEARPLATE
2	1	D3512-3	SPACER
3	A/R	2059B	HARDCOAT



D3512-041 WEARPLATE ASSY

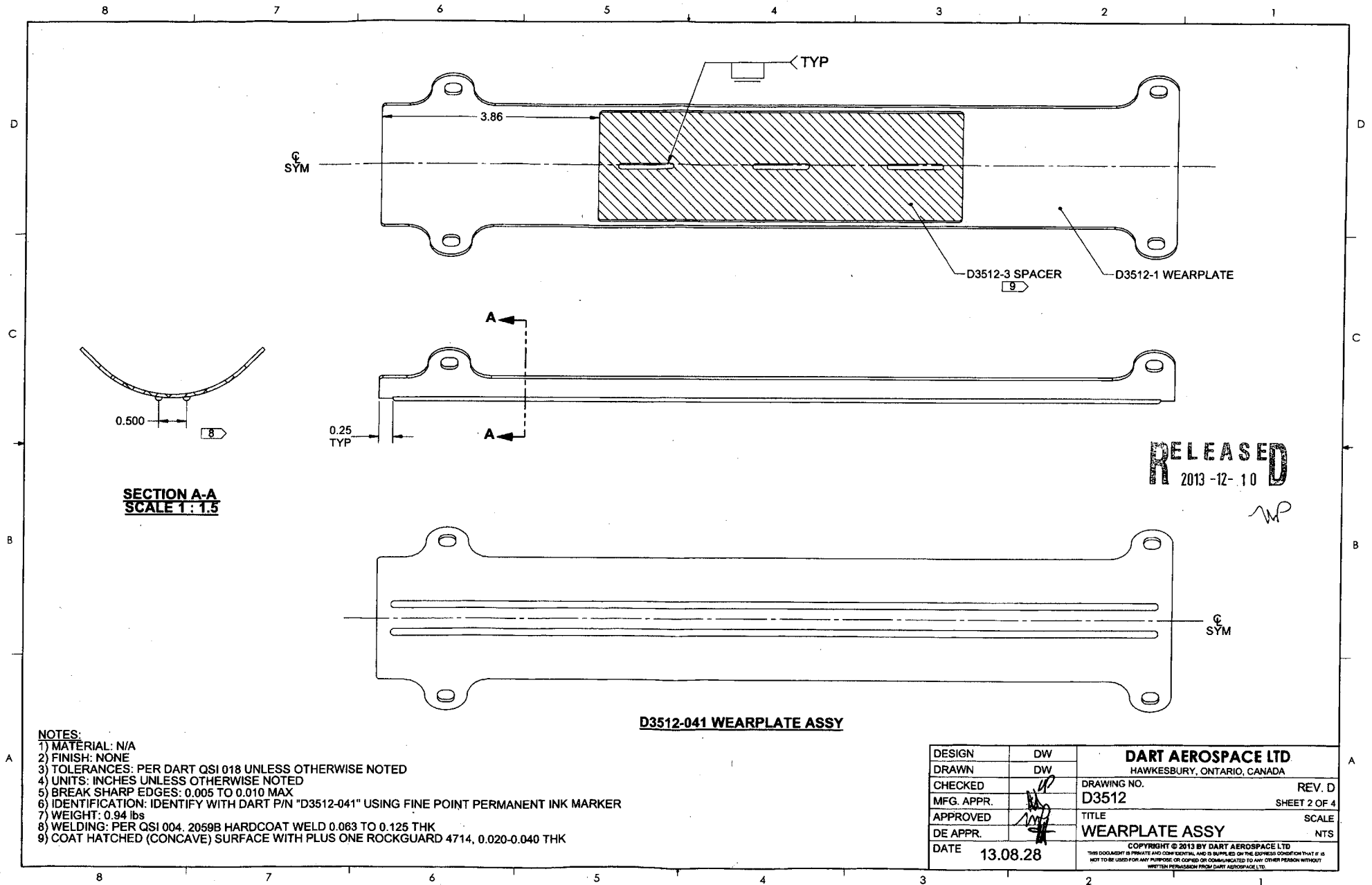
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. ~~118475~~ MLJ

130272 1405-22

W

RELEASED
R 2013-12-10
WP

DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	13.08.28	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR LOANED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



RELEASED
2013-12-10
MP

SECTION A-A
SCALE 1:1.5

D3512-041 WEARPLATE ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3512-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.94 lbs
- 8) WELDING: PER QSI 004, 2059B HARDCOAT WELD 0.063 TO 0.125 THK
- 9) COAT HATCHED (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714, 0.020-0.040 THK

DESIGN	DW	DART AEROSPACE LTD	
DRAWN	DW	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3512	REV. D
MFG. APPR.		SHEET 2 OF 4	
APPROVED		TITLE WEARPLATE ASSY	SCALE NTS
DE APPR.		COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	13.08.28		

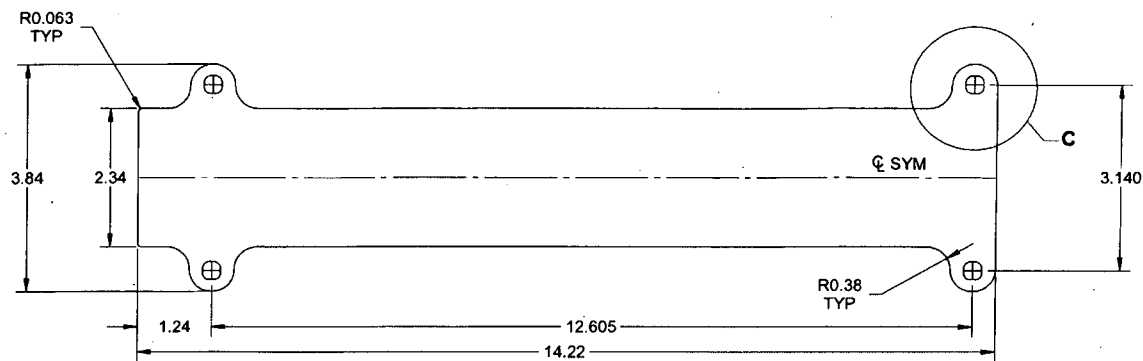
8 7 6 5 4 3 2 1

D

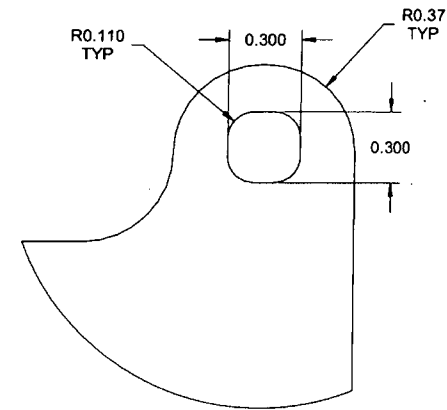
C

B

A



D3512-1F



DETAIL C
SCALE 2X

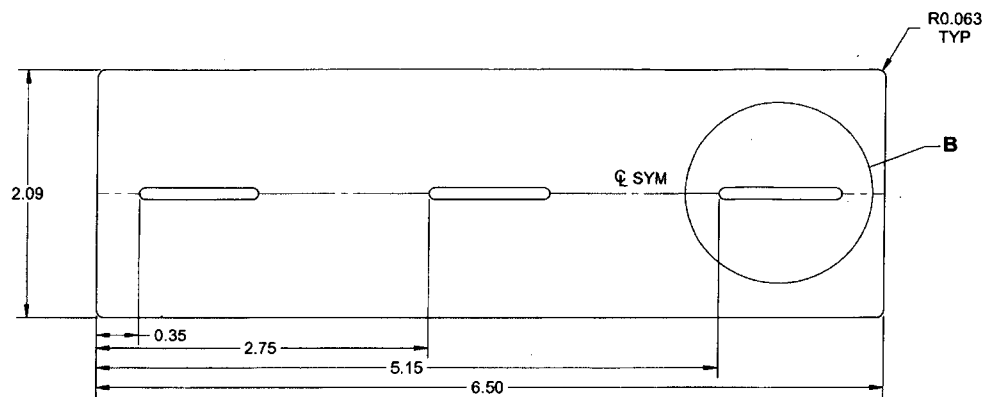
RELEASED
2013-12-10
WP

NOTES:

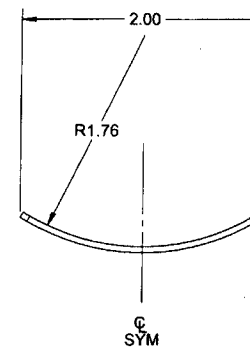
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240
18 GAUGE 0.063 THICK (REF DART SPEC. MS304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	MS	DRAWING NO. D3512	REV. D
MFG. APPR.	MS		SHEET 3 OF 4
APPROVED	MS	TITLE	SCALE
DE APPR.	MS	WEARPLATE ASSY	NTS
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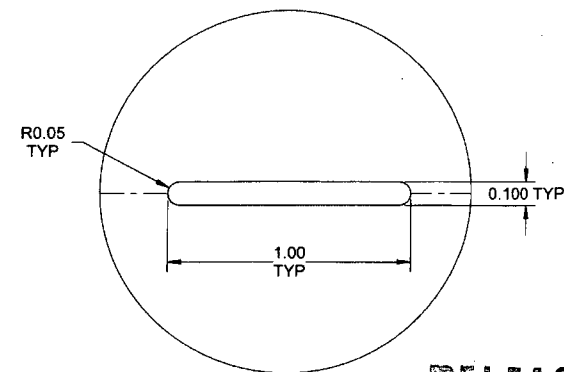
8 7 6 5 4 3 2 1



D3512-3F FLAT PATTERN



D3512-3 SPACER
MAKE FROM D3512-3F



DETAIL B
SCALE 2X

RELEASED
2013-12-10

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 18 GAUGE 0.050 THICK (REF DART SPEC. MS304S18GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.19 lbs

DESIGN	DW	DART AEROSPACE LTD	
DRAWN	DW	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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